

For ENG

Work Order ID 143980

Tuesday, March 29, 2016 9:27:56 AM

143980

Page 1

Item ID: D5396-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Net Bracket Assembly, LH

Start Date: 3/30/2016 Start Qty: 1.00

1

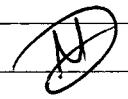
Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: 

Date: 16-3-29

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5396

A

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut D5396-1F as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

①

on 16/03/30

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

①

on 16/03/30

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

①

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[illegible]

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Page 3

Item ID: D5396-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Net Bracket Assembly, LH
 Start Date: 3/30/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/1/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00				1	FF		MAR 31 2016
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Gloss Black (Alum) (Ref: QSI005 4.3.5.13)	0.00							
180									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:05 OVEN TEMPERATURE: 325 FINISH TIME: 1:35								

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Item ID: D5396-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Net Bracket Assembly, LH

Start Date: 3/30/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									DAS 15 9-89
200		0.00							
200									
Small Fab	Memo	0.00							
Small Fab	1- INSTALL NUT PLATE AS PER DWG								
	2- INSTALL D-RING AS PER DWG								
210	QC5- Inspect part completeness to step on W/O	0.00							
210									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 APR 01 2016

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Item ID: D5396-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Net Bracket Assembly, LH

Start Date: 3/30/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Identify as per dwg & Stock Location: <u>St</u>	0.00							
220									
Packaging	Memo	0.00							
Packaging									
230	QC21 - Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

16-04-01APR 01 2016Issue to: RD16-1012-0116-04-01

Picklist Print

Page 1

Tuesday, March 29, 2016 9:28:03 AM

Work Order ID: 143980

143980

Parent Item: D5396-041

D5396-041

Parent Item Name: Net Bracket Assembly, LH

Start Date: 3/30/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.03.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	240.6000	3.2	3.368421			
M6061T6S 080									**				
6061-T6 .080 Sheet													

Location	Loc Qty	Loc Code
MAT020	240.6	
134217	32	
m132772	37.3	
m133587	49.5	
m133828	25.8	
m134551	96	

D5397-1

Manufactured No

200 Each 0.0000 2

2

DAS
30
9-89

APR 01 2016

D5397-1

D Ring

MS20426AD3-4

Purchased No

200 Each 6,251.000 4

4

**
②

MS20426AD3-4

RIVET

Location	Loc Qty	Loc Code
CCK004	4885	
m134294	4885	
GA	1008	
m131697	1008	
ST312	358	
m131697	358	

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Picklist Print

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Work Order ID: 143980

Parent Item: D5396-041

Parent Item Name: Net Bracket Assembly, LH

143980

D5396-041

Start Date: 3/30/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

MS21059L4

Purchased

No

200

Each

46.0000

2

2

DAS
30
9-89

MAR 30 2016

MS21059L4

Nutplate

**

Location

Loc Qty

Loc Code

CCK007

20

m133483

20

ST301

26

m133938

6

m134474

20

2

MS27039-4-10

Purchased

No

200

Each

56.0000

2

2

DAS
30
9-89

MAR 30 2016

MS27039-4-10

Screw

**

Location

Loc Qty

Loc Code

ST279

56

m131885

56

2

NAS1149F0432P

Purchased

No

200

Each

1,755.000

2

2

DAS
30
9-89

MAR 30 2016

NAS1149F0432P

WASHER

**

Location

Loc Qty

Loc Code

ST260a

1000

M134502

1000

ST262

634

M133990

634

st268

121

M132677

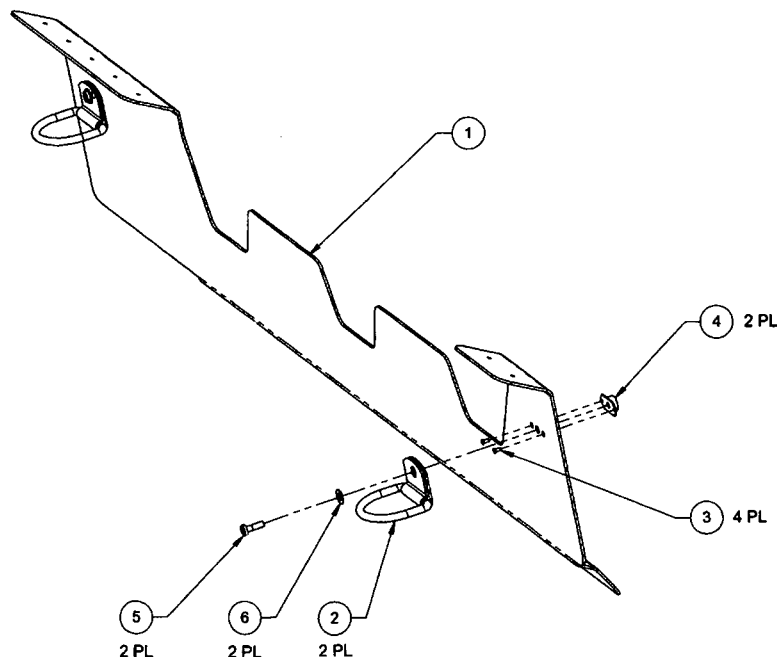
121

2

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5396-041	NET BRACKET ASSY LH
1	1	D5396-1	NET BRACKET LH
2	2	D5397-1	D RING
3	4	MS20426AD3-4	RIVET, SOLID, CSK
4	2	MS21059L4	NUTPLATE
5	2	MS27039-4-10	SCREW, PAN-HEAD
6	2	NAS1149F0432P	WASHER



D5396-041 NET BRACKET ASSY LH

RELEASED
2016-03-23
5016-548

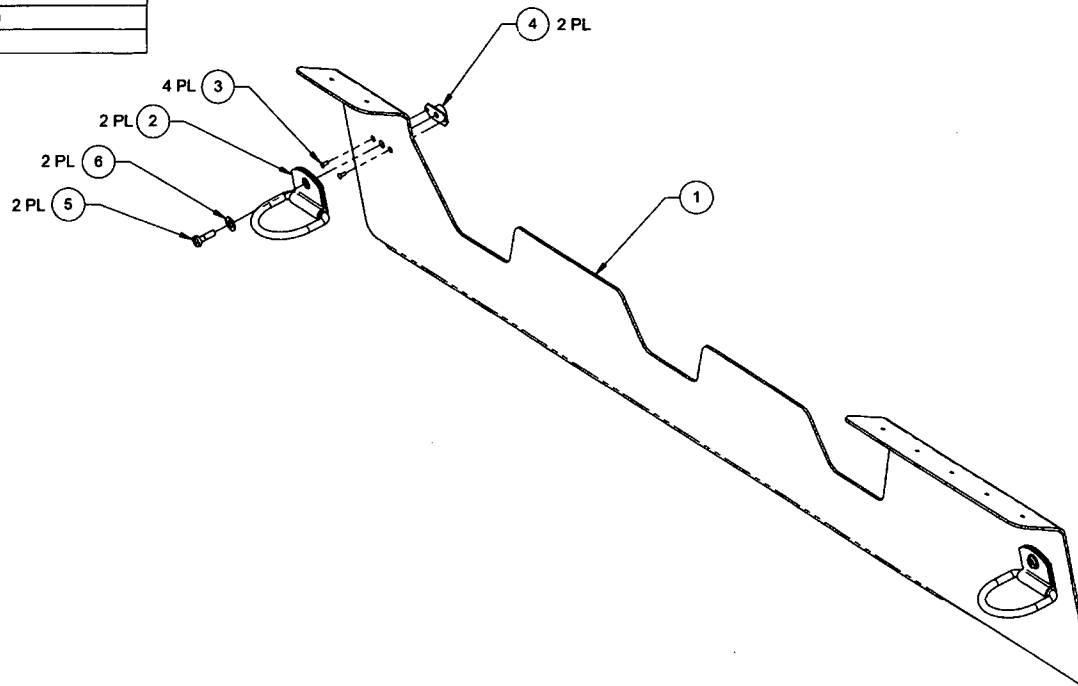
NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 7) WEIGHT: 2.77 lbs

16-3-29
143980

APPROVED

A	NEW ISSUE	AK	16.02.11
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5396	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	NET BRACKET ASSY	NTS
DATE	16.02.11	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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ITEM	QTY	P/N	DESCRIPTION
	X	D5396-042	NET BRACKET ASSY RH
1	1	D5396-2	NET BRACKET RH
2	2	D5397-1	D RING
3	4	MS20426AD3-4	RIVET, SOLID, CSK
4	2	MS21059L4	NUTPLATE
5	2	MS27039-4-10	SCREW, PAN-HEAD
6	2	NAS1149F0432P	WASHER



D5396-042 NET BRACKET ASSY RH

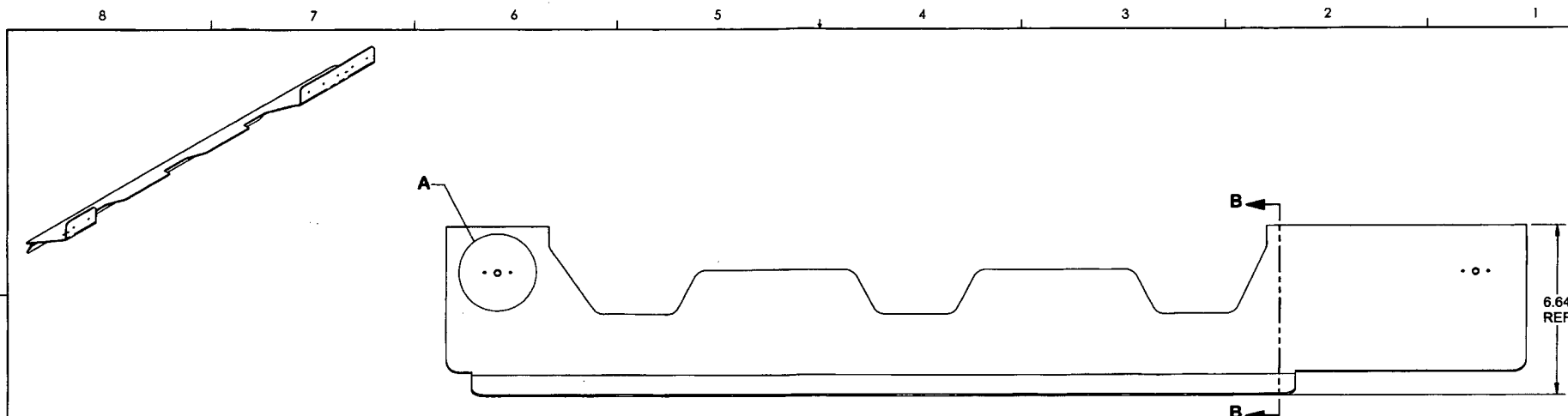
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 2.77 lbs

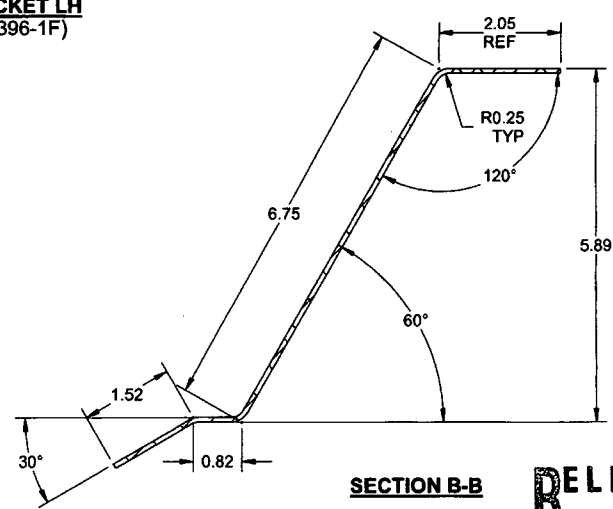
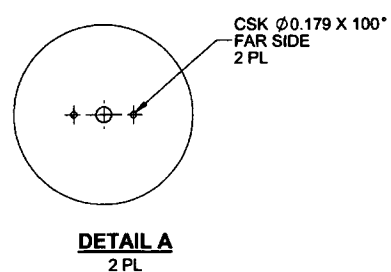
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DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5396	SHEET 2 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	NET BRACKET ASSY	NTS
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RELEASED
2016-03-23



D5396-1 NET BRACKET LH
(MAKE FROM D5396-1F)



- NOTES:**
- 1) MATERIAL: MADE FROM D5396-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.34 lbs

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DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5396	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	NET BRACKET ASSY	NTS
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2016-03-23

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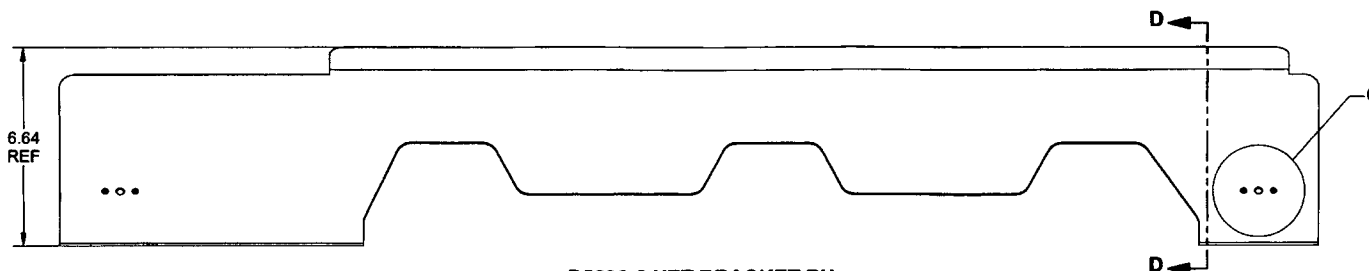
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1

D

D



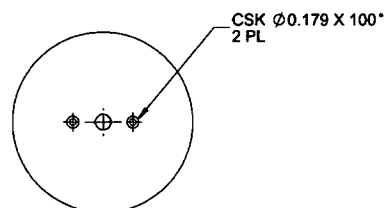
D5396-2 NET BRACKET RH
(MAKE FROM D5396-1F)

C

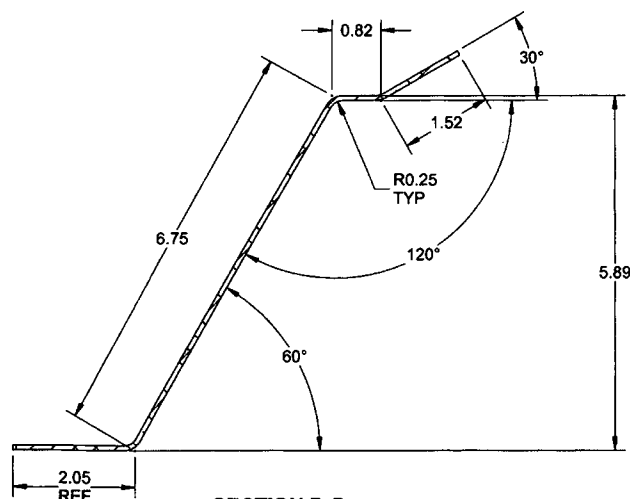
C

B

B



DETAIL C
2 PL



SECTION D-D

NOTES:

- 1) MATERIAL: MADE FROM D5396-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.36 lbs

RELEASED
2016-03-23

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DESIGN	DB	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5396	SHEET 4 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	NET BRACKET ASSY	NTS
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